



Canadian Induracoat Corporation

Vancouver - Calgary - Victoria

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Material Processing & Handling Information

Material: FSS 45DC

Material Type: Fast Set Spray Polyurea Coating

Application: Concrete, Tile, CMU Block, Wood and other porous substrates

Application Process: High pressure heated equipment with impingement gun

Process Equipment:	Pumps	Dispensing Gun
Graco:	EXP-1 (Electric) EXP-2 (Electric) H-XP2 (Hydraulic) H-XP3 (Hydraulic)	Fusion AP (Air Purge) Fusion MP (Mechanical Purge) GX-7 Standard (Mechanical Purge) GX-8 (Mechanical Purge) Probler (Air Purge) Probler P2 (Air Purge)
Gusmer:	FF 2500 (Hydraulic) FF 3500 (Hydraulic) H-20/35 (Pro Hydraulic)	GX-7 Standard (Mechanical Purge) GX-7 400 (Mechanical Purge) GX-7 DI (Mechanical Purge) GX-8 (Mechanical Purge) Gap Pro (Air Purge)
GlasCraft:	MX, MXII (Pneumatic) MH, MHII, MHIII (Hydraulic) SuperMaxi, Guardian A Series	Probler (Air Purge) Probler P2 (Air Purge)
Gama:		Master Gun (Air Purge)
Process Temperature:	170° F optimum (150°F min., 190°F max.)	
Process Pressure:	2,000 - 2,500 psi optimum (1,700 psi min., 3,500 psi max.)	
Gel Time:	20-30 seconds	
Tack Free:	90 seconds	
Light Traffic:	60-120 minutes	
Full Cure:	7 days	
Moisture Content:	Calcium chloride test: 3 lb./24 hr./1,000 ft ² Tramex concrete moisture meter: 5% maximum	
Application Temperature:	-20°F and higher	
	Note that FSS 45DC will cure at sub-freezing temperatures, but the effects may impact the application in a variety of ways. It is recommended that material and equipment ambient temperatures be kept at 50°F or above. Frozen concrete substrates with high moisture content will affect coating adhesion and long-term performance.	
Dew Point:	Substrate temperature must be 5°F above dew point and rising before application of coating materials.	

Surface Prep:	Abrasive blast per ICRI Technical Guideline No. 03732 or SSPC SP13. Achieve a concrete surface profile of ICRI CSP-3 to CSP-5.																		
Surface contaminates:	Check for soluble salts on surfaces to be coated. Test with Chlor*Test. If amount of soluble salts exceeds recommended limits, treat with Chlor*Rid. Repeat process until acceptable limits are reached. Maximum amounts of soluble salts (micrograms per square centimeter): Chlorides - 3 immersion, 7 non-immersion Nitrates - 5 immersion, 10 non-immersion Sulfates - 10 immersion, 20 non-immersion																		
Substrate Parging:	Formed walls with honeycombing or concrete surfaces with large exposed aggregate. Recommended that the surface is rubbed or parged to eliminate surface defects. Use Five Star Structural Concrete.																		
Surface Primer:	<p>VersaFlex Quick Mender (8 to 10 wet mils): Two-component sealer and primer. Maximum overcoat time: 24 hours, after which a light recoat is required (2 to 4 wet mils).</p> <p>Versaflex VF 20 (8 to 10 wet mils): Two-component primer. Maximum overcoat time: 72 hours, after which a light recoat is required.</p>																		
Adhesion Testing:	Adhesion to concrete: Minimum 150 psi. Cohesive failure of concrete is optimum. Pull values will vary depending on concrete strength.																		
Coating Application:	<p>Coating thickness will vary depending on intended use, surface roughness and profile. The International Concrete Repair Institute (ICRI) has developed a standard for Concrete Surface Profile (CSP) ranging between 1 (smoothest) and 9 (roughest).</p> <p>The following chart gives approximate minimum coating thickness to achieve a continuous coating using the ICRI CSP standard.</p> <table border="1"> <tr><td>CSP-1 & CSP-2</td><td>45 - 55 mils</td></tr> <tr><td>CSP-3</td><td>55 - 60 mils</td></tr> <tr><td>CSP-4</td><td>60 - 65 mils</td></tr> <tr><td>CSP-5</td><td>65 - 70 mils</td></tr> <tr><td>CSP-6</td><td>70 - 75 mils</td></tr> <tr><td>CSP-7</td><td>75 - 80 mils</td></tr> <tr><td>CSP-8</td><td>80 - 85 mils</td></tr> <tr><td>CSP-9</td><td>85 - 90 mils</td></tr> </table> <p>** Please review the <i>Spray Gun Configuration Recommendation PDF</i> for specific modules and tips.</p>			CSP-1 & CSP-2	45 - 55 mils	CSP-3	55 - 60 mils	CSP-4	60 - 65 mils	CSP-5	65 - 70 mils	CSP-6	70 - 75 mils	CSP-7	75 - 80 mils	CSP-8	80 - 85 mils	CSP-9	85 - 90 mils
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	Storage Temp	Storage	Special Handling																
'A' Side	50°F min. 70°F optimum	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Use dry air desiccant for intake vent on drum.																
'B' Side	50°F min. 70°F optimum	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Mix well with mixer to re-disperse any settled pigment.																
	Safety:	Please consult product MSDS for full details. Safety glasses, rubber gloves, protective clothing, organic vapor or fresh air respirator.																	

